

Work Order ID 86090

June-20-12 12:59:13 PM

86090

Page 1

Item ID: D3017-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Back Frame Assembly

Start Date: 20/06/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 04/07/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/20 Tooling:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3017	Rev B								
100	Weld per dwg A/R 4130 rod Batch: <u>M 118875</u>	0.00							
100	Large Fab								
Large Fab	Memo	0.00							
	1-Cut D3017-1, D3017-3 and D3017-5 tubes as per Dwg D3017								
	2-Bend D3017-1 and D3017-3 tube as per dwg D3017 (DT8598)								
	3-Drill holes in D3017-5 Using DT8622								
	4-Deburr								
	5-Assemble and weld as per Dwg D3017 using Welding Jig DT8598								
	6-Drill holes in back frame using DT8621								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
110	QC								
Quality Control	Memo	0.00							

① 12-7-12

1 8 2E 12/07/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

8.26/16

Quality Control

130

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

130

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11:00
320°F
11:30

140

QC3- Inspect Part Finish

0.00

140

QC

Memo

0.00

Quality Control

IX ~~φ~~ MZ 12/07/10

1 ~~φ~~ PL 12-7-10

W121279

W/O:		WORK ORDER CHANGES					
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Page 3

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Item Name: Back Frame Assembly

Stop *NS2*

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Cust Item ID:

Required Date: 04/07/2012 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: Date:

Tooling:

Run Start *NR1*

QC: Date:

SPC (Y/N):

Date:

Stop *NR2*

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

150 Identify as per dwg & Stock Location: G.A

0.00

150

Packaging

Memo

0.00

Packaging

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

12/17/18 *[Signature]*
MCS 12/07/10

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

June-20-12 12:59:17 PM

Page 1

Work Order ID: 86090

Parent Item: D3017-041

Parent Item Name: Back Frame Assembly

86090

D3017-041

Start Date: 20/06/2012

Required Date: 04/07/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP A01.09.19New issue EC
IPP RevB: as per revB DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4130NT0.750W.083		Purchased	No			100	f	37.8970	2.458	2.587368			

M4130NT0 750W 083

4130 RD Tube .750 x.083W

**

Q 12-7-12

Location

Loc Qty

Loc Code

MAT033

37.897

117579

13.98

117973

23.917

2.58

M4130NT0.750W.049

Purchased

No

100

f

105.9200

11.125

11.71053

M4130NT0 750W 049

4130 RD Tube .750 x.049W

**

Q 12-7-12

Location

Loc Qty

Loc Code

MAT033

105.92

120350

65.61

121025

40.31

11.7

D3017-11

Manufactured

No

100

Each

50.0000

2

2

D3017-11

cap

**

Q 12-7-12

Location

Loc Qty

Loc Code

WA021

50

76851

50

2

D3017-7

Manufactured

No

100

Each

6.0000

3

3

D3017-7

Lug

**

Q 12-7-12

Location

Loc Qty

Loc Code

WA021

6

70905

6

3

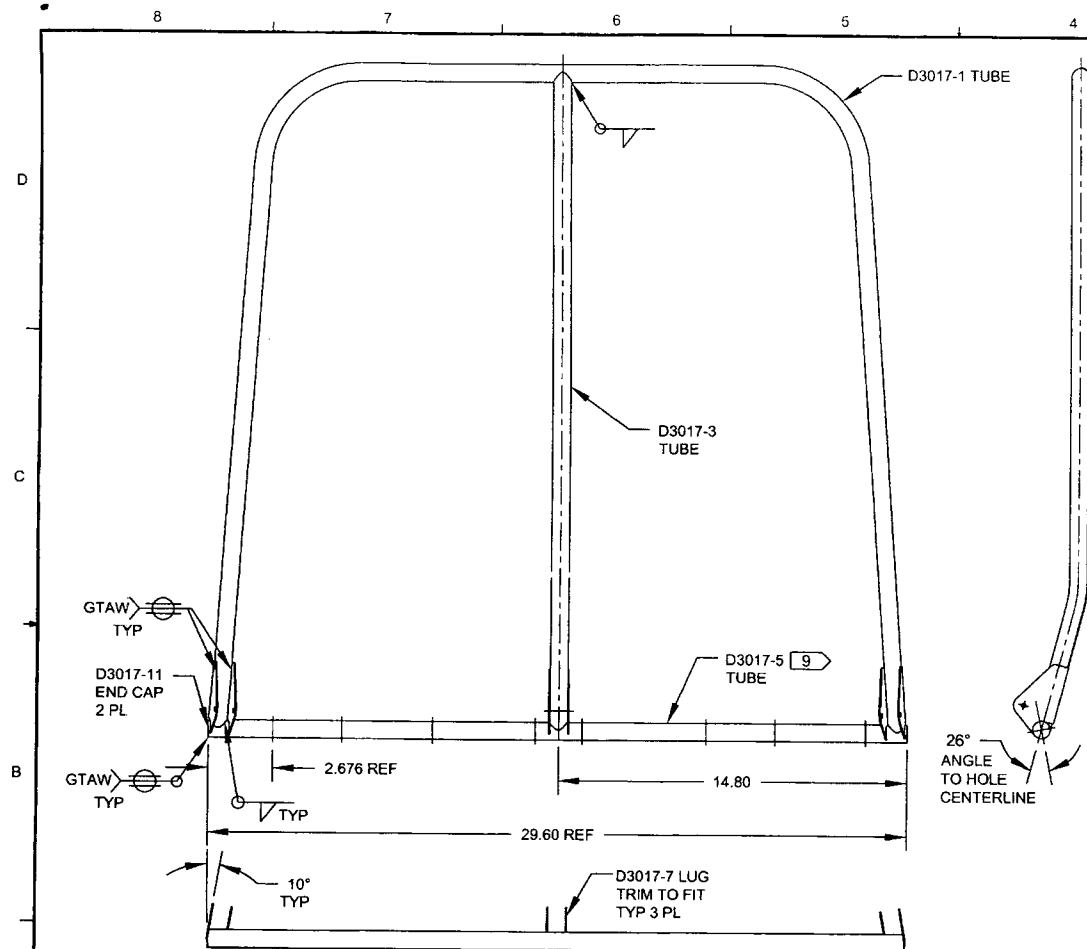
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ITEM No.	QTY	PART NUMBER	DESCRIPTION
1	X	D3017-041	BACK FRAME ASSEMBLY
2	1	D3017-1	TUBE
3	1	D3017-3	TUBE
4	1	D3017-5	TUBE
5	3	D3017-7	LUG
6	2	D3017-11	END CAP

DRILL Ø0.128 HOLES TO LINE UP
WITH D3023-1 BACK PANEL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 86090 ULJ
12/06/20

RELEASED
2010-02-02
wp

D3017-041 BACK FRAME ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3017-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 4.50 lbs
- 8) WELD PER DART QSI 004

9) ROTATE SO THAT PILOT HOLES ARE ANGLED AS SHOWN IN END VIEW.

B	REFORMAT DWG. -5 TUBE WALL THKNS REVD (A8-3) SHEET 3 & 4 ADDED TO CLARIFY DRAWING. RADIUS CHANGED FROM R4.00 TO R3.75 (B4-2, B2-2). HOLE SIZE CHANGED FROM Ø0.191 TO Ø0.257 (C6-3, C3-3)	JPH	10.01.13
A	NEW ISSUE	CP	01.05.18
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.01.13		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3017

REV. B

SHEET 1 OF 4

TITLE

BACK FRAME ASSEMBLY

SCALE

NTS

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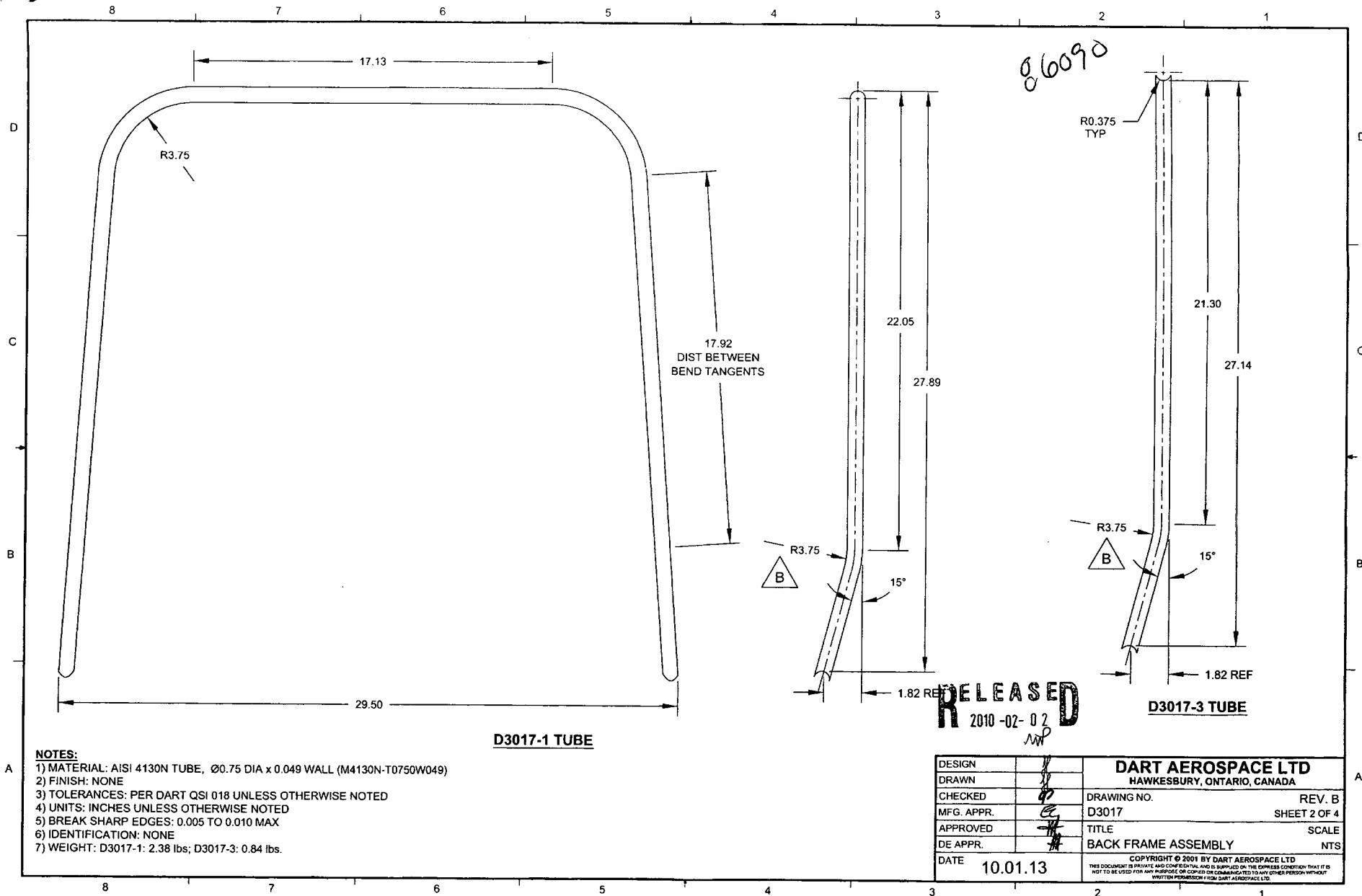
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



NOTES:

- 1) MATERIAL: AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3017-1: 2.38 lbs; D3017-3: 0.84 lbs.

DESIGN		DART AEROSPACE LTD	
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CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3017	SHEET 2 OF 4
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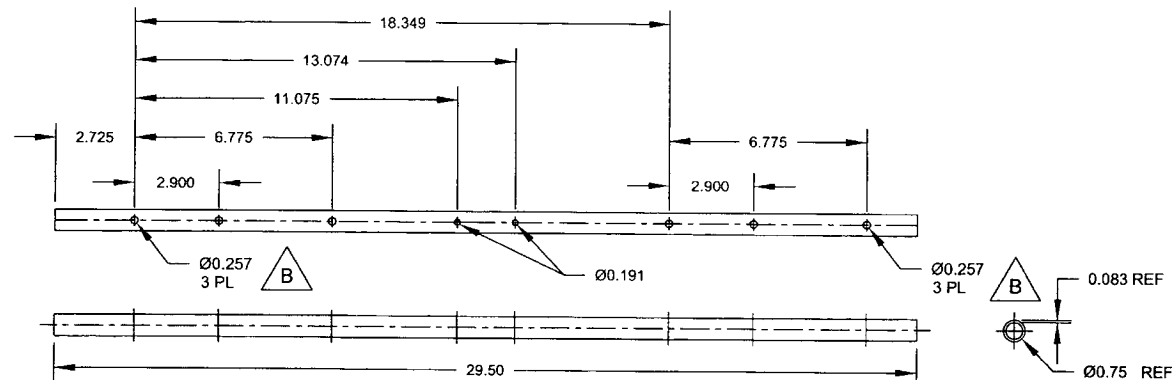
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NOTE: Date & initial all entries

86096



D3017-5 TUBE

RELEASED
2010-02-02
MP

NOTES:

- 1) MATERIAL: AISI 4130N TUBE, Ø0.75 DIA x 0.083 WALL (M4130N-T0750W083)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.89 lbs



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MFG. APPR.		D3017	SHEET 3 OF 4
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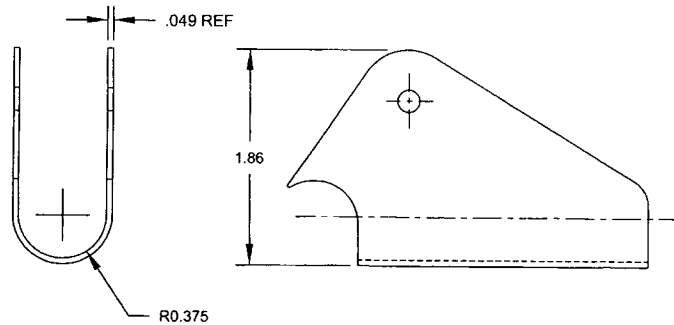
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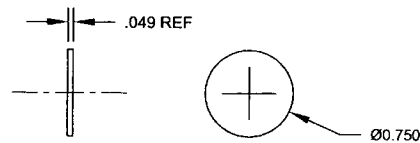
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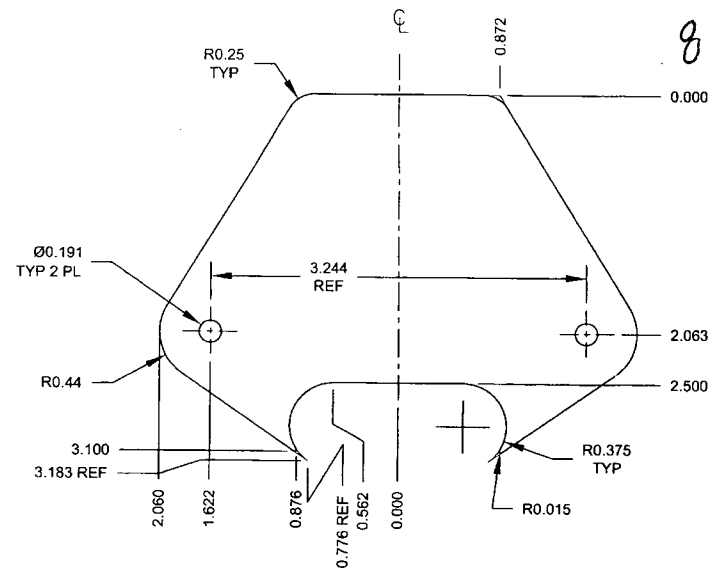
NOTE: Date & initial all entries



D3017-7 LUG
BENDING DETAIL
MAKE FROM D3017-7F



D3017-11 END CAP



D3017-7F FLAT PATTERN
PART IS SYMMETRIC
ABOUT CENTERLINE

RELEASED
2010-02-02

NOTES:

- 1) MATERIAL: AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: -7: 0.12 lbs; -11: 0.01 lbs.

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CHECKED		DRAWING NO.	REV. B
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